

GREEN

64617

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CAP	
Job Number	: 27488		Part Number	: D2855	
Estimate Number	: 10519		Drawing Number	: D2855 REV. A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/12/2006		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/30/2006	
Previous Run	: 26351		Qty:	25	Um: Each
Written By					
Checked & Approved By	: <u>HD</u> 06.06.13				
Comment	: Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: <u>1490</u> <u>c Locell 15/04</u> <u>25</u> 100 Cast per Dwg D2855 Material Release Note Required	
2.0	D2855P	Cap	
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 25.0000 Each(s) CAP	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached	
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64" 3- Deburr	

Monday, 6/12/2006 3:25:36 PM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 27488

Part Number: D2855

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Job-0823

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING POWDER COATING

Comment: POWDER COATING *GREEN*

Powder Coat White-Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 4/

06/11/14 x 4

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

a.m

06/11/14

(4)

9.0 ALS71032225 INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 50.0000 Each(s)

INSERT

Pick:

Qty Part Number

Description

Batch

2 ALS7-1032-225

Insert

M19393

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

a.m 06/11/14

(4)

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

a.m 06/11/14

(4)

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FC 06/11/14 (4)

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *F05*

FC 06/11/14 (4)

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Process Sheet

Customer: CU-DAR001 Part Helicopters Services

Drawing Name: CAP

Job Number: 27488

Part Number: D2855

Job Number:



Seq. #:	Machine Or Operation:	Description :
13.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Inspection Level 21

06/11/15

Job Completion



06/11/15

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELÉRIE (1988) LTD
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD714-718 CALAIS, DORVAL, QC H9P-2P3
TEL: (514) 631-1331 FAX: (514) 631-8448Expédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Packing
Date: 14/08/2006 Slip No. 6111

Hawksbury, ON, K6A 1K7

Votre No. Commandé 1490
Your order No.

Ceci est pour certifié que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillante sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
100	DRWG D 2855 rev A	Z098046	A356.2	B#0619301 Ingot #815076

Analyse
Analysis (as in ingot)

(Si)	7.00%	(Al)	balance
(Fe)	0.08%		
(Cu)	<0.01%		
(Mn)	<0.01%		
(Mg)	0.44%		
(Zn)	<0.01%		
(Ti)	0.16%		

Donne
Yield :Résistance à la tension :
Tensile Strength :Allongement par pouce carré :
P.S.I. Elongation : %Pour et au nom de
For and on behalf of :FONDERIE D'ALUMINIUM ET MODELÉRIE (1988) LTD
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTDDept/Dep :
Par/Per : 